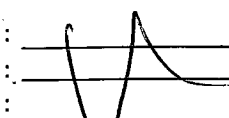


Date: Monday, 29/10/2007 12:55:00 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206667101
Job Number	: 35413		
Estimate Number	: 10804		
P.O. Number	: <i>N/A</i>	Part Number	: D206667101
This Issue	: 29/10/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: CHG 002
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 29263	Drawing Revision	: <i>N/A</i>
	Type : LANDING GEAR	Material	: <i>N/A</i>
Written By	: 	Due Date	: 05/11/2007
Checked & Approved By	: _____	Qty:	1 Um: Each
Comment	: _____		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1
 BUFF CUFFS, DRILL OEM HOLES PER CHG 002

2.0	D206667101	Crosstube Installation
-----	------------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Installation
 B *16590*

SR 7-11-2

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

4.0	SPRAY PAINTING	SPRAY PAINTING
-----	----------------	----------------



Comment: SPRAY PAINTING
 MASK AND
 RE-PRIME & REPAINT CUFFS

MM 07 11 07

①

5.0	QC14	INSPECT SPRAY PAINT
-----	------	---------------------



Comment: Inspect Spray Paint

5 07/11/08

6.0	D2873043	Nut Plate Assembly
-----	----------	--------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:
 Qty Part number Description Batch
 2 D2873-043 Nut Plate *33422*

MM 07 11 07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 29/10/2007 12:55:00 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206667101

Job Number: 35413

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2873-045

Nut Plate

34077

ml 07 11 07

8.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number

Description Batch

14 MS20601AD4W8

Rivet M105057

ml 07 11 07

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/07

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP

11.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

M100426

W

12.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

M103641

W

13.0

AN960JD516

Washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

M104156

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: Mar 09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 29/10/2007 12:55:00 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206667101

Job Number: 35413

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

M10x6.25

[Handwritten signature]

15.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

M10x5.30

[Handwritten signature]

16.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

M10x1.56

[Handwritten signature]

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

[Handwritten signature]

Job Completion



[Handwritten signature]

[Handwritten signature]

[Handwritten signature]

DART		TEL: 1-613-632-3336	
TRANSPORT CANADA APPROVAL # 09-89		FAX: 1-613-632-4443	
P/N	D206-667-101	CHG	CHG001
DESC	Crosstube Fwd High	SIC	SH01-5
LOT	B16590	SIC	SR01304NY
MODEL	206A/B	SIC	
US PATENTS: 5735480		MADE IN CANADA	
CANADA FOREIGN PATENTS PENDING			

[Handwritten signature]



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-141	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26

UNDER REVIEW
06.08.10 PH
re.dwn detail F

Qty	Part Number	Description
X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

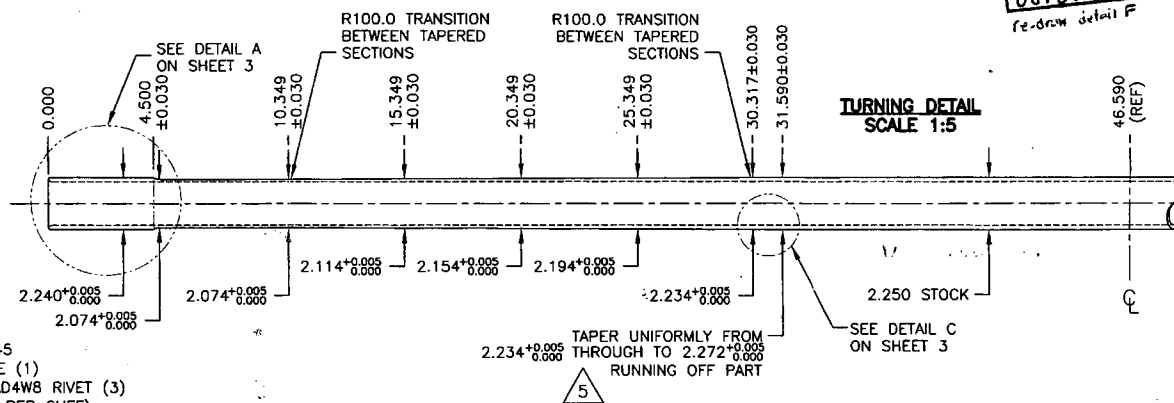
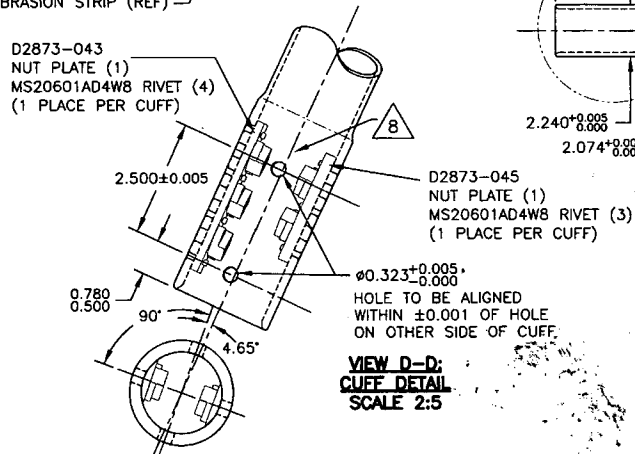
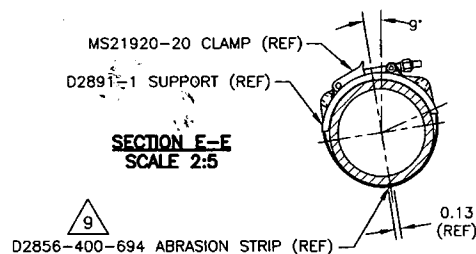
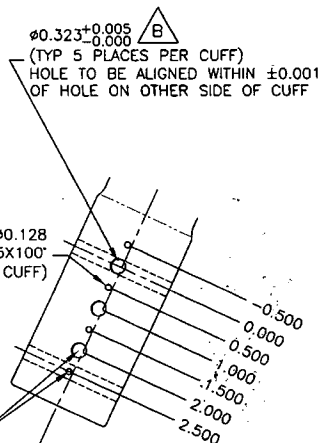
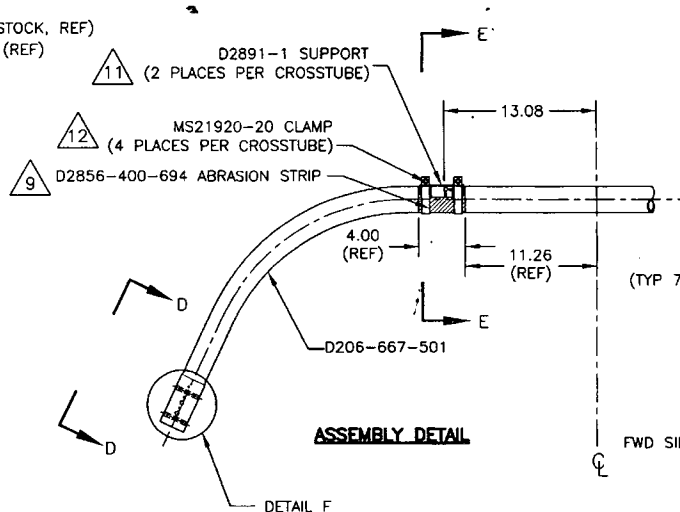
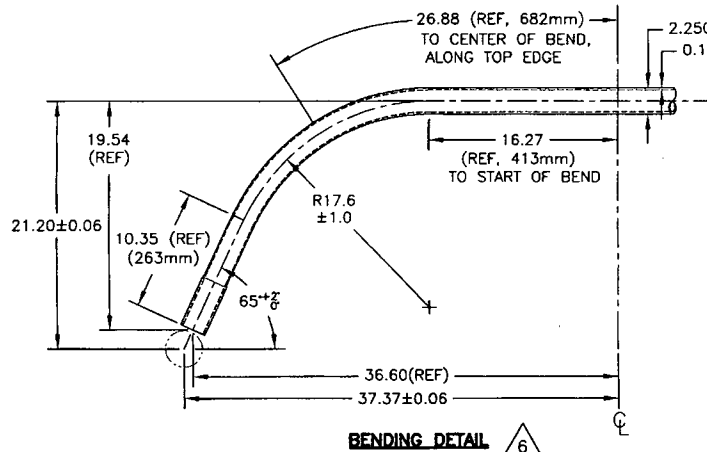
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

W/O 35413

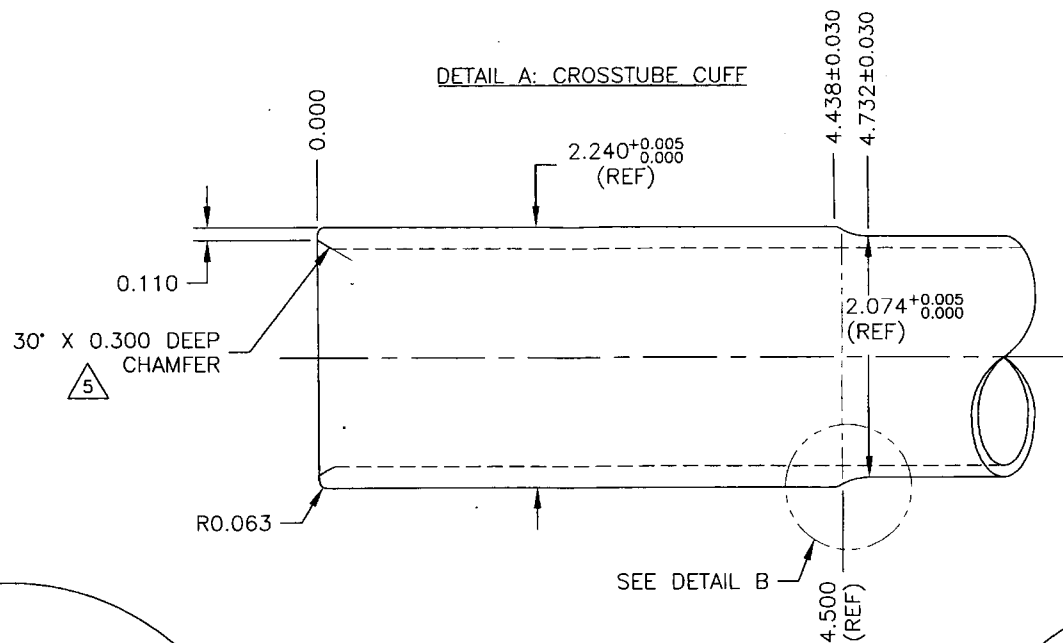
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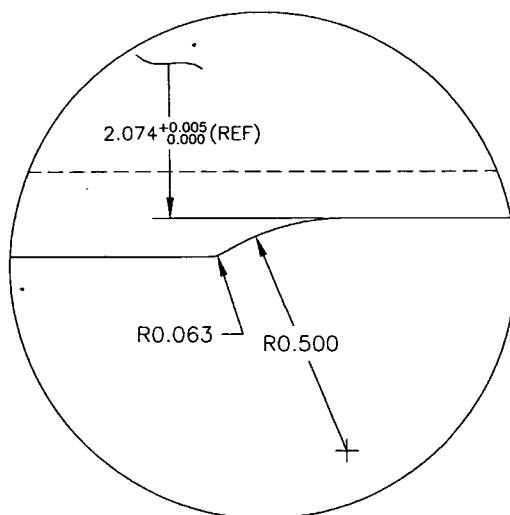
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06.08.10 PH
re-draw detail F

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DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)		SCALE 1:10	

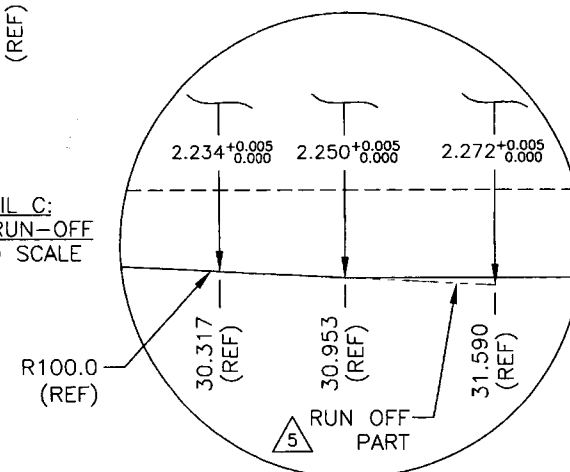


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06.08.10 PH
re-draw detail F

05.07.26



DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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CHECKED	DS	APPROVED	HUS	DRAWING NO.	D206-667-141
DATE	05.07.26	TITLE	CROSSTUBE ASS'Y (206B HIGH FWD)	REV. B	SHEET 3 OF 3
				SCALE	1:1

